

Work Order ID 75819

75819

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Item ID: D2814 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut
 Start Date: 31/10/2011 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 14/11/2011 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/13 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2814	Rev A1								

100 NC BRAKE 0.00
 100
 Brake NC Memo 0.00
 Brake NC 1-Length as per Dwg D2810 and spec control Dwg D2727 using Jig DT80122-
 Deburr cut at 5.420

2 FF 12-02-15

Ae 11.11.04 (X2)

110 QCS- Inspect part completeness to step on W/O 0.00
 110
 QC Memo 0.00
 Quality Control

Sinclair

(72)

120 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00
 120
 Powdercoat Memo 0.00
 Powder Coating START TIME: 1h00 OVEN TEMPERATURE:
1h30 FINISH TIME: 400°F

4 & (SPR) 12/03/06

M120 222

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location <u>265</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

2XØ M-12/03/06

12/3/6 SD (2)

12/3/7 JH

12-03-6 (2)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Parent Item: D2814

D2814

Parent Item Name: Strut

Start Date: 31/10/2011

Required Date: 14/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C02.06.18Added finishing level (Ref. ECN 435)KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	155.6323	2	4.210526			

M304TR0 500W 0.35

304 RD Tube .500 x .035W

**

Ac 11.11.04.

Location

Loc Qty

Loc Code

MAT017

155.6322723

115535

2.33

116720

1.66068

117598

16.6415923

118702

35

119160

100

4.2

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

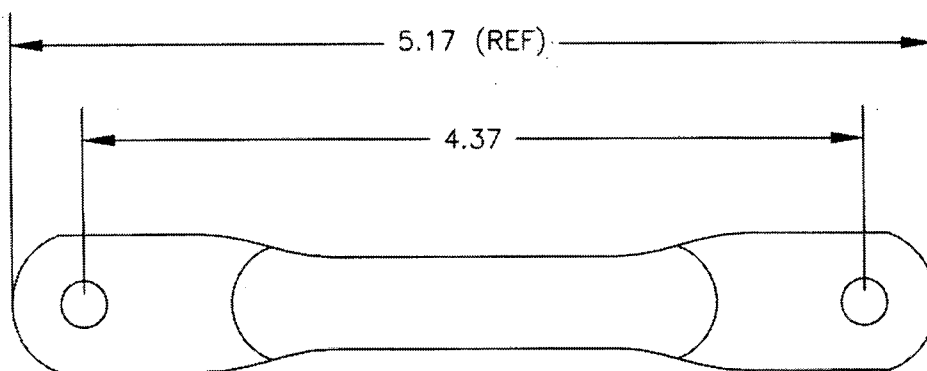


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2814	REV. A SHEET 1 OF 1
DATE 99.09.29		TITLE STRUT	SCALE 1:1
A	99.09.29	NEW ISSUE	
A1	CP 02.03.26	ADD FINISH	

RELEASED
99.10.12 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35819 M.C.J

11/10/31



PUNCH ENDS PER SPEC
CONTROL DRAWING D2727

NOTE:

MATERIAL: 304/316/318 SS, 0.50 OD x 0.035 WALL,
ENSURE SEAMLESS TUBING IS USED

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QOS 4.3 **AN**

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